

Work Order ID 153802

Friday, November 25, 2016 7:43:20 AM

153802

Page 1

Item ID: D4078-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp Half

Start Date: 12/5/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/12/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS
21

Date: NOV 29 2016

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4078

B

100

0.00

100

Bandsaw

Memo

0.05

Jeaspa Bandsaw

Cut blank 2.700" long

8

217-1-5

110

0.16

110

HAAS 1

Memo

0.19

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA929

Folio rev: AA

Dwg Rev: B

8

217-1-6

Deburr

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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153802

Friday, November 25, 2016 7:43:20 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 12/5/2016 **Start Qty:** 4.00 ***4***

Required Date: 12/12/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.01

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.01

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.02

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER :																					

Work Order ID 153802

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Page 3

Item ID: D4078-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp Half
Start Date: 12/5/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/12/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>m 12/27/16</i> Memo	0.00 0.01				<i>8</i>	<i>0</i>	<i>17-01-09</i>	<i>333</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>8</i>			<i>DAS 38 9-89</i> <i>JAN 10 2017</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>S1074</i> Memo	0.00 0.01				<i>8</i>		<i>JAN 10 2017</i>	<i>DAS 6 9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

Start Date: 12/5/2016 **Start Qty:** 4.00 ***4***

Required Date: 12/12/2016 **Req'd Qty:** 4.00 ***4***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

1 80

QC

Memo

0.07

Quality Control

vs 17/1/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																			
Misidentified ☐	Past Due ☐																				

Picklist Print

Friday, November 25, 2016 7:43:20 AM

Page 1

Work Order ID: 153802

153802

Parent Item: D4078-1

D4078-1

Parent Item Name: Clamp Half

Start Date: 12/5/2016

Required Date: 12/12/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	9.7257	0.223	0.938947			

M6061T6B1 250X01 250

2L 17-1-5

6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT003

9.7257

m134776

6.4867

m135377

3.239

1.84

DQA: _____ Date: _____

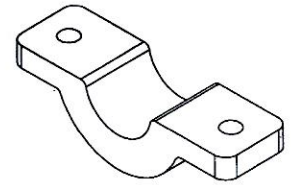
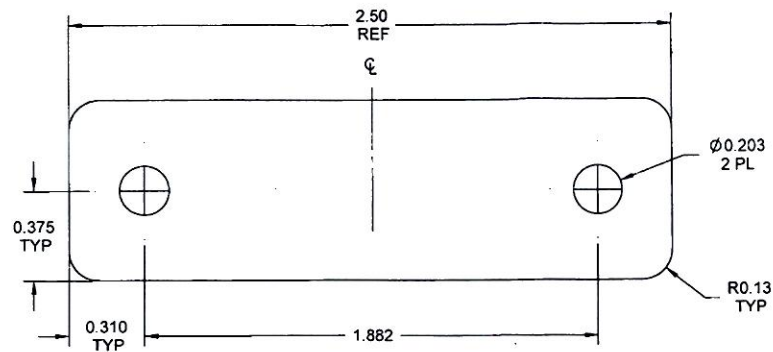


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

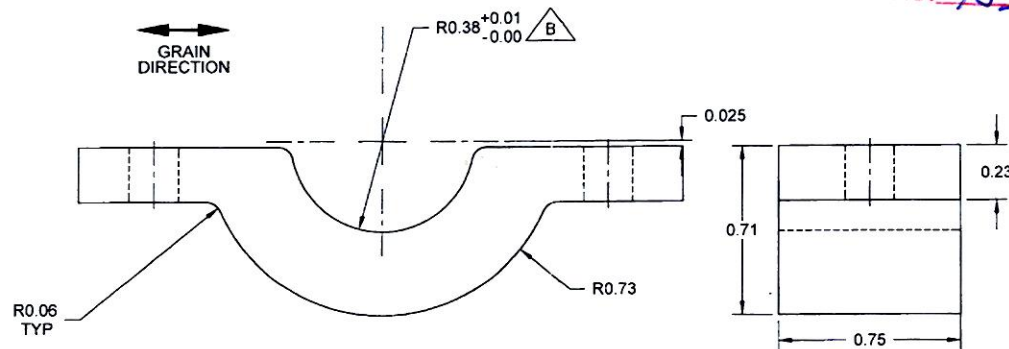
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OTHER : _____					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 153802MLS
10-11-29



D4078-1 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T652 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

RELEASED
2010-09-07

B	R0.38 was R0.48.	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED			
MFG. APPR.		DRAWING NO.	REV. B
APPROVED		D4078	SHEET 1 OF 1
DE APPR.		TITLE	SCALE
DATE		CLAMP HALF	NTS
10.07.30		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	